



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

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**D5854-041**  
**Job Sheet 207404**

POSITIVE  
RECALL

NO 20.02.20



**POSITIVE RECALL**

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

Part No: D5854-041

Job Qty: 8 pcs

Part Name: Bracket Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/20

Job Tracking No:

Created By: Jennifer Renwick

Description:

Due Date: 3/6/20

Type: Stock

Note: URF 2020-525 DWG D5854 Rev A IPP Rev. A 2020.01.30 New issue DP Verify DD

Ship Via:

Placed by M. St. Hilaire  
APR 20.02.20

### Bill of Materials

### Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	8 pcs	3/6/20	3/6/20	0.00	8.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 9	8 pcs	3/6/20	3/6/20	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	8 pcs	3/6/20	3/6/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS 24	
							QC 5 - 22	9-89	
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

**PRIORITY**

MAL



Container No: S267896



Part: D5854-041

Job No: 207404

Serial No/Batch: S267896

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA  
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Date: 03/31/20

Plex 2/26/20 9:58 AM Dart.lajeunesse.marie

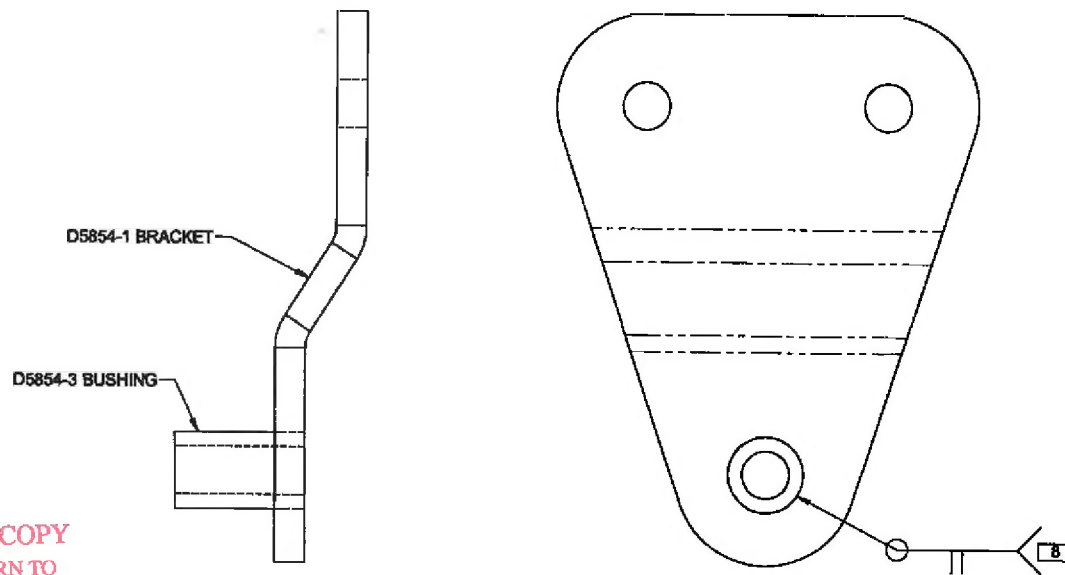
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140	Packaging 3-1 - Stock - B4B 8 pcs	3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150	QC 21 - SA 8 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
<p>Part Op 110 - Weld per dwg A/R S.S. rod Batch: <u>M139022</u></p> <p>Descriptions: 120 - QC9- Inspect visual per QSI004- Fusion Welds</p> <p>130 - (QC5- inspect part completeness to step on W/O)</p> <p>140 - identify as per dwg &amp; Stock Location: _____</p> <p>150 - QC21- Final Inspection - Work Order Release</p>					
<b>Job BOM</b>					
Part / Item	Component Name	Quantity	Operation	Container	
D5854-1	Bracket	8 pcs (1 ea)	110-Large Fab - Welded Assy-1		
D5854-3	Bushing	8 pcs (1 ea)	110-Large Fab - Welded Assy-1		



Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D5854-1	8	0	0
	D5854-3	8	0	0
Part Specifications				
Specifications could not be found.				

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QTY -041	P/N	DESCRIPTION
X	D5854-041	BRACKET WELDMENT
1	D5854-1	BRACKET
1	D5854-3	BUSHING



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 207404 MJS  
20-02-26

**D5854-041 BRACKET WELDMENT**  
(DERIVED FROM AERO DESIGN P/N 70422-06)

UNDER REVIEW  
URF 2020-525 20.02.20 (NO)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
  - 7) WEIGHT: 0.10 lbs
  - 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.

RELEASED

2020 FEB 19  
ECH 2020-124

APPROVED

A	NEW ISSUE	ZF	20.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.27		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5854

TITLE

BRACKET

REV. A

SHEET 1 OF 3

SCALE

NTS

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

Job: _____  Part No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	<b>DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Water Jet <input type="checkbox"/>            Supplier <input type="checkbox"/>            Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
<b>Root Cause</b>  <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		<b>FAULT CATEGORY</b>  <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced  <input type="checkbox"/> Bending  <input type="checkbox"/> Crushing  <input type="checkbox"/> Cracks  <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist  <input type="checkbox"/> Marks/Chatter  <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination  <input type="checkbox"/> Misaligned/off center  <input type="checkbox"/> BOM/Route  <input type="checkbox"/> Broken/Damage/Defect  <input type="checkbox"/> Incomplete/Unclear Instructions  <input type="checkbox"/> Drill Holes  <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Folio/Program  <input type="checkbox"/> Grain Direction  <input type="checkbox"/> Weld  <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Out of Sequence  <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong  <input type="checkbox"/> Outside Tolerance  <input type="checkbox"/> Drawing  <input type="checkbox"/> Finish  <input type="checkbox"/> Part Lost/Missing  <input type="checkbox"/> Misread         </div> </div>			
Other/Details:					